

# Work Order ID 78268

Wednesday, January 04, 2012 10:53:44 AM

**\*78268\***

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Item ID: D412-785-002-401

Revision ID:

Item Name: Faceplate

Start Date: 1/4/2012 Start Qty: 1.00

Required Date: 1/4/2012 Req'd Qty: 1.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *12-01-04*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-785-002-101	B								
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<i>6061.063</i>	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr as required								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*B 12-1-4*

*(1)*

*HB 12-1-4*

*Flat*

*Edge*

*Ship Jan 5th*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-785-002-401

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Faceplate

Stop

**\*NS2\***

Start Date: 1/4/2012

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/4/2012

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Sizeloy

Flat only

130

Small Fab

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.  
COUNTER SINK AS PER DWG

N A MF 2-0-04

140

Bend as per dwg

0.00

**\*140\***

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D412-785-002

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Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Faceplate

Stop

**\*NS2\***

Start Date: 1/4/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/4/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Weld per dwg A/R Aluminum rod Batch:

0.00

**\*160\***

Large Fab

Memo

0.00

Large Fab

163

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*163\***

QC

Memo

0.00

Quality Control

*A* *ME* *12.01.04*

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Wednesday, January 04, 2012 10:53:44 AM

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Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Faceplate

Start Date: 1/4/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/4/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

165

QC5- Inspect part completeness to step on W/O

0.00

**\*165\***

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

175

QC3- Inspect Part Finish

0.00

**\*175\***

QC

Memo

0.00

Quality Control

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Wednesday, January 04, 2012 10:53:44 AM

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Revision ID:

Item Name: Faceplate

Stop **\*NS2\***Start Date: 1/4/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/4/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	Identify as per dwg & Stock Location: _____	0.00							
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**\*180\***

Packaging	Memo	0.00							
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Packaging

12/15/05

190	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*190\***

QC	Memo	0.00							
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Quality Control

CK 12/01/05

MF 12-01-05

# Picklist Print

Wednesday, January 04, 2012 10:53:43 A

Page 1

Work Order ID: 78268

Parent Item: D412-785-002-401

Start Date: 1/4/2012

Required Date: 1/4/2012

Parent Item Name: Faceplate

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	168.0696	1.4	1.4736842			

1B12-1-4

Location

Loc Qty

Loc Code

MAT021

168.0695684

113608

0

116308

14.4555684

117285

75.414

119331

49.2

119802

29

119802

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

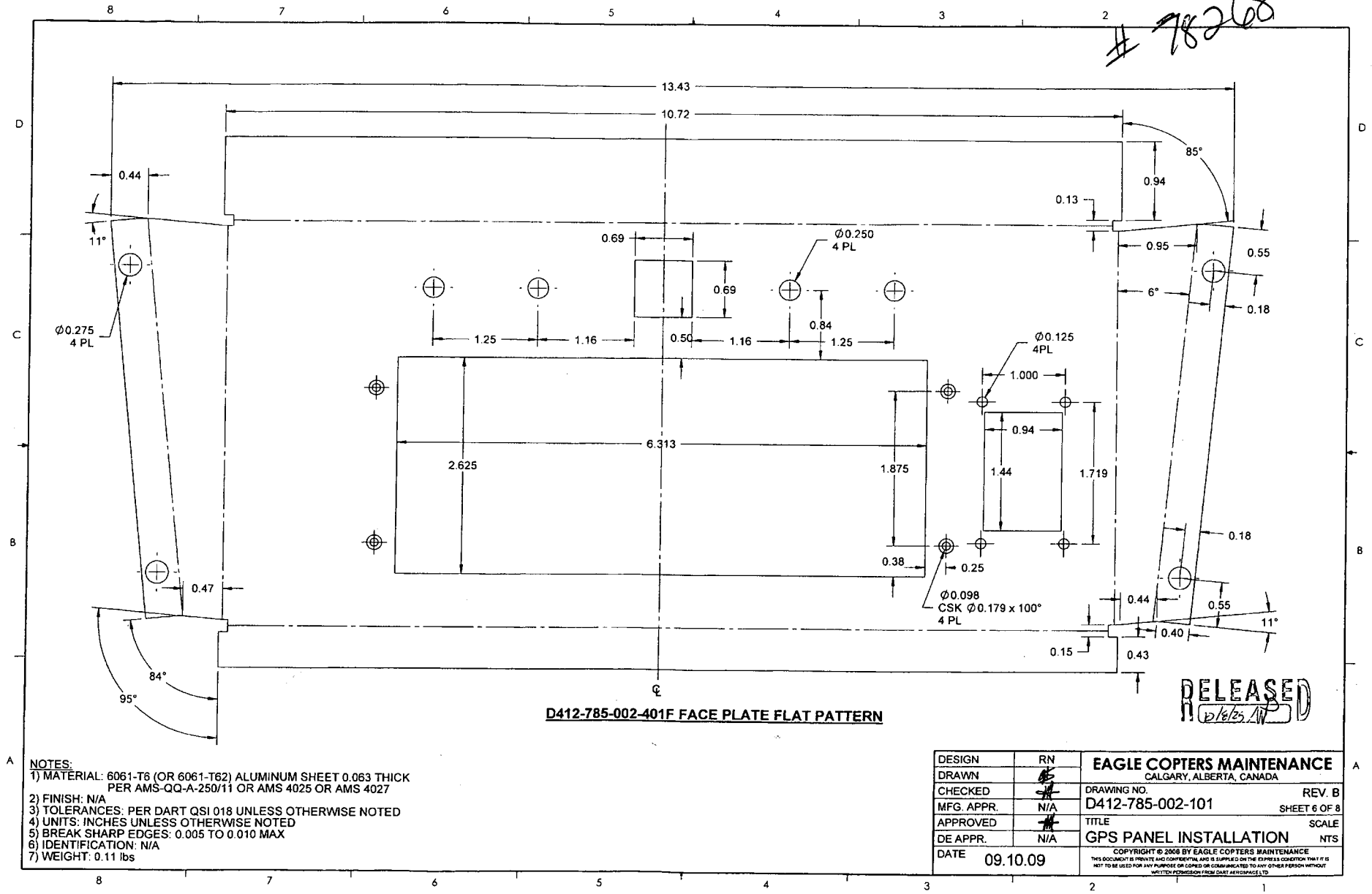
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# 78268



- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.11 lbs

